

Work Order ID 84307

84307

Page 1

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Item ID: D119-675-013 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Maintenance Step
 Start Date: 09/05/2012 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 23/05/2012 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/05/09 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSI 9510	<u>A</u> <u>B</u> <u>4</u>	<u>4B</u>							
100	DOCUMENT CONTROL	0.00							
100									
DC	Memo	0.00							
Document Control	Photocopy bluefile & type labels per PPPD119-675-013 CHG001								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

DAS
06
9-88
SMB

13-4-11 (4x)

4 13-04-10 JB

SMB DAS 06 9-88 (4x) 13-4-11

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D119-675-013 Accept ***N900040100*** Setup Start ***NS1***
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 Item Name: Maintenance Step
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 Required Date: 23/05/2012 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Pick Kit	0.00							
130									
Packaging	Memo	0.00							
Packaging	Package as per PPPD119-675-013 FG 123 REV. A								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									



8 13-411

MCS 13-04-11

13-04-11

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 84307

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Parent Item: D119-675-013

D119-675-013

Parent Item Name: Maintenance Step

Start Date: 09/05/2012

Required Date: 23/05/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A NEW ISSUE 10-09-07 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4084-1 Maintenance Step		Manufactured	No			100	Each	2.0000	2	8			
<div> <div> *D4084-1* Maintenance Step </div> <div> 4x 84308 2x 82916 </div> </div>													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST123		2							
				61973		2							
AN5-7A Bolt		Purchased	No			100	Each	2,599.000	4	16			
<div> <div> *AN5-7A* Bolt </div> <div> 2x 61973 124561 </div> </div>													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST337		2599							
				119017		2599							
AN5-11A Bolt		Purchased	No			100	Each	517.0000	4	16			
<div> <div> *AN5-11A* Bolt </div> <div> 123533 </div> </div>													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST337		517							
				118191		13							
				119512		504							
NAS1149D0563J Washer		Purchased	No			100	Each	3,794.000	8	32			
<div> <div> *NAS1149D0563J* Washer </div> <div> 122452 </div> </div>													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST298		3794							
				119546		1794							
				121255		2000							

W/O:		WORK ORDER CHANGES						
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NOTE: Date & initial all entries

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D119-675 REV. B AND
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D119-675 REV. 1
REF. FAA STC: SR00948SE & EASA STC EASA.IM.R.S.01458

INTRODUCTION

The purpose of this service instruction is to introduce the new D119-675-013 Maintenance Step Kit which consists of (2) maintenance step/tiedown brackets that are attached to the existing shipping hardpoints at STA 130 (3310mm) and WL 58 (1475mm). The D119-675-013 kit increases the area of the existing maintenance step for improved security and provides an additional tie down point for the aircraft.



FINISH

Before or after installation, prime and paint to match the aircraft paint scheme per the Aircraft Maintenance Manual.

INSTALLATION

Install D119-675-013 Maintenance Step at the location shown in Figure 1, using (4) AN5 bolts. Apply a layer of Proseal 890 or MIL-S-8802 class B2 sealant between D4084-1 and aircraft skin. Torque bolts to 100-140 in-lb (11.3-15.8 Nm).

WEIGHT & BALANCE

INSTALLATION	WEIGHT	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D119-675-013 MAINTENANCE STEP KIT	1.06 lb 0.48 kg	0.0 in 0.0 m	0.0 in-lb 0.0 m-kg	+ 130.3 in + 3.31 m	+ 138.1 in-lb + 1.59 m-kg

PARTS LIST

ITEM	QTY -013	PART NUMBER	DESCRIPTION
	X	D119-675-013	MAINTENANCE STEP KIT
1	2	D4084-1	MAINTENANCE STEP
2	4	AN5-7A	BOLT
3	4	AN5-11A	BOLT
4	8	NAS1149D0563J	WASHER (OR AN960JD516)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 84302-1115
12/25/09

B	ADDED FINISH NOTE	MB	10.11.29
A	NEW ISSUE	RF	10.04.12
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	5		
CHECKED	JP	DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9510	SHEET 1 OF 2
APPROVED	TH	TITLE	SCALE
DE APPR.	TH	STEP/TIEDOWN KIT	NTS
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W/O:		WORK ORDER CHANGES					
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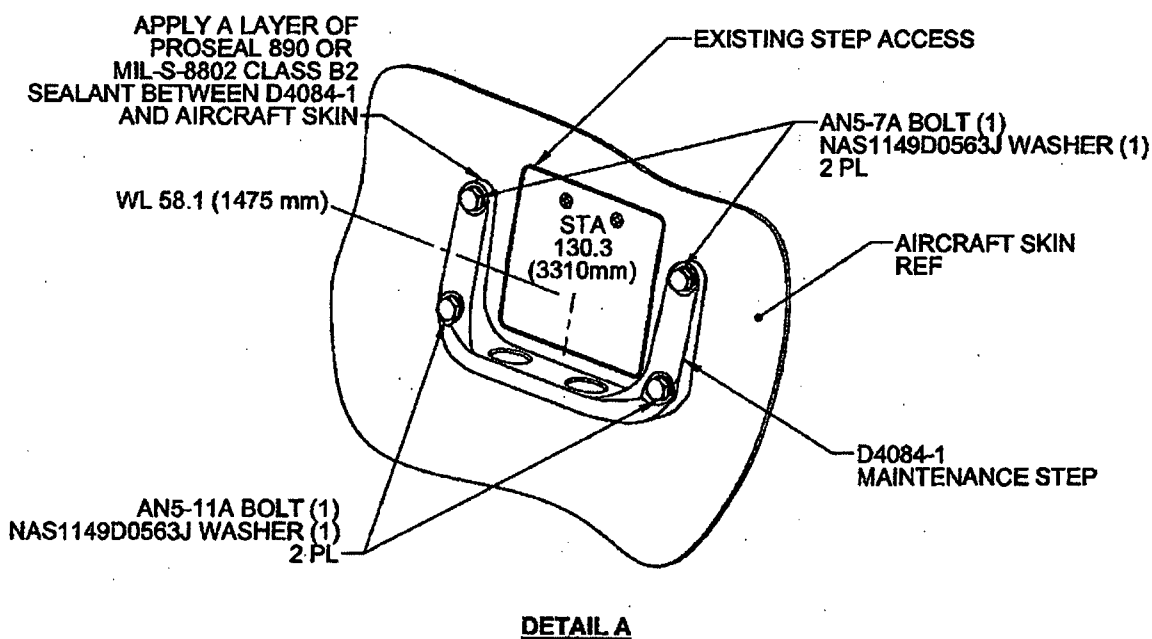
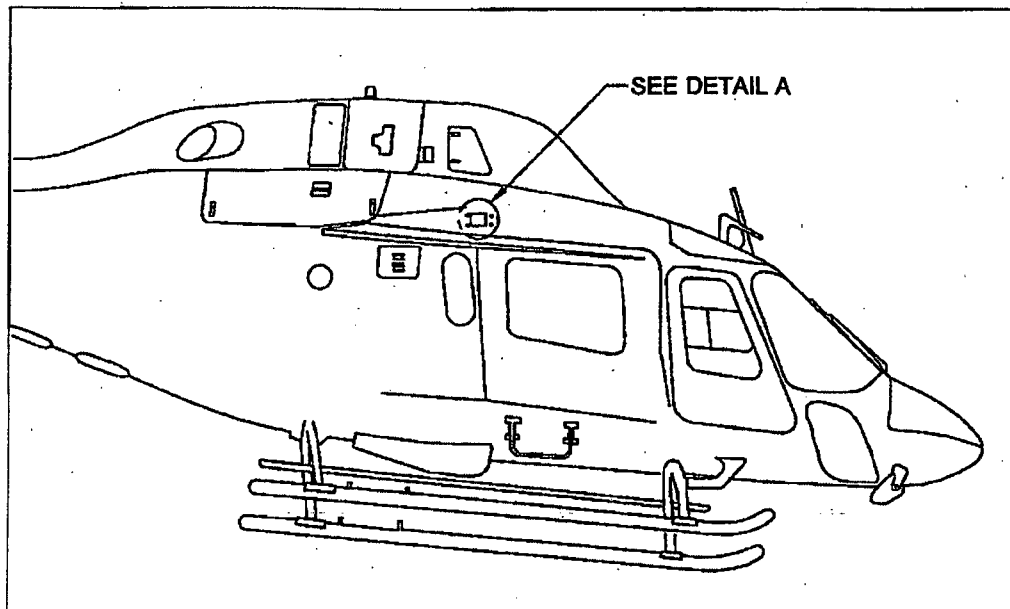


FIGURE 1. - D119-675-013 MAINTENANCE STEP INSTALLATION
(RH SIDE SHOWN, LH OPPOSITE)

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9510	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		STEP/TIEDOWN KIT	NTS
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W/O:		WORK ORDER CHANGES					
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SD 13-4-11

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2	4	AN5-7A	BOLT
3	4	AN5-11A	BOLT
4	8	NAS1149D05633	WASHER (OR AN960JD516)

B	ADDED FINISH NOTE	MB	10.11.29
A	NEW ISSUE	RF	10.04.12
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9510	SHEET 1 OF 2
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Work Order ID 84307***84307***

May-09-12 1:37:47 PM

Item ID: D119-675-013

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Maintenance Step

Start Date: 09/05/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 23/05/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Run Start ***NR1***Approvals: Process Plan: *MCJ*Date: *12/05/09* Tooling:

Date:

Stop ***NR2***

QC:

Date: SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSI 9510	<i>A B C</i>	<i>4B</i>							
100	DOCUMENT CONTROL	0.00							
100									
DC	Memo	0.00							
Document Control	Photocopy bluefile & type labels per PPPD119-675-013 CHG001								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

MCJ 1304-11

(4)